

Date: Wednesday, 1/18/2006 4:04:59 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: COVER	
Job Number	: 25556F		Part Number	: D32021	
Estimate Number	: 10287		Drawing Number	: D3202 REV B1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 1/18/2006 S.O. No. : N/A		Drawing Revision	: B1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 2/15/2006	
Previous Run	: 25442F		Qty:	10 u	
Written By	: See comment below		Um:	Each	
Checked & Approved By	: See above (see date)				
Comment	: Est Rev:B No Longuer Made In House 05-11-06 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <u>00000450</u> <i>06/01/26</i> E-mail or Ship DXF file to vendor Laser cut flat pattern as per Dwg Possible supplier: Ind. Laser Material realease note is required.	
2.0	D32021F	Cover	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: <u>10</u> 0000 Each(s) Cover	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached	
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/04/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 25556F

Part Number: D32021

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5AD 06/04/02 10

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/04/02 10

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/4/02 10

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 86 St

6/4/03 10

Job Completion



Inspection Level 21 06/04/04. 10
u.Dar.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

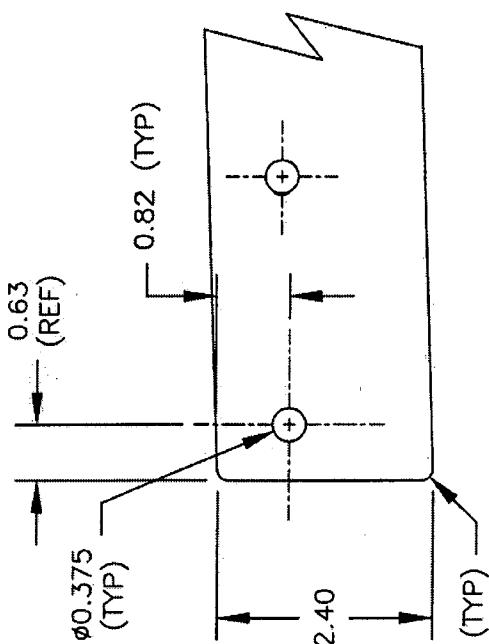
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3202	SHEET 1 OF 1
DATE		TITLE	SCALE
03.10.16		COVER	1:10

A	01.01.01	NEW ISSUE
B	03.10.16	REDESIGN; PART NOW CURVED
B1	04.05.14	CLARIFY MID-SPAN DIMENSION

RELEASED

03.11.07

DETAIL A
SCALE 1:2

SHOP COPY
RETURN TO
ENGINEERING

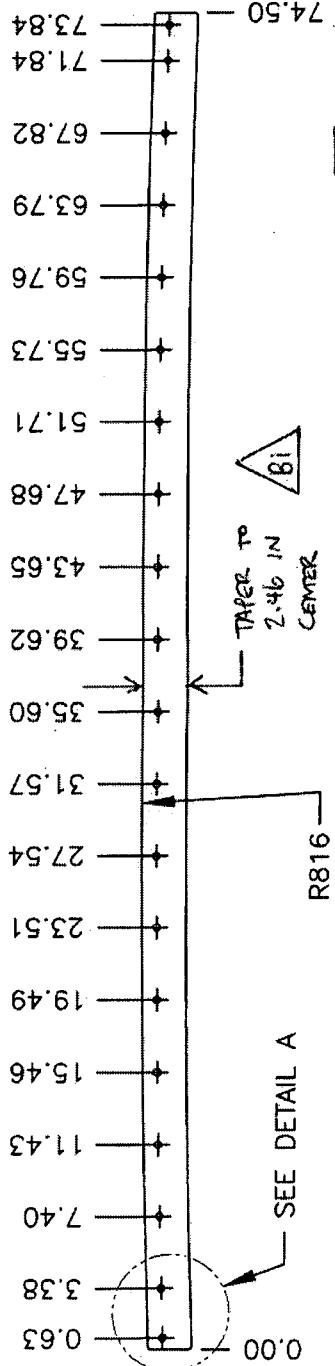
UNCONTROLLED COPY
SUBJECT TO AIRLINE DENT
WITHOUT NOTICE

WORK ORDER

NO 25556 F

D3202-1 COVER

- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.032 THICK (REF DART SPEC. M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

**Copyright © 2003 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

MO #

12311 HORSESHOE WAY
12311 HORSESHOE WAY
Phone: (604) 272-2422

SOLD TO:
INDUSTRIAL LASER CUTTING LTD
#7 - 7504 VANTAGE PLACE
PHONE: 604 946 4152

DELTA BC V4G 1AS

RICHMOND BC V7A 4X6
RICHMOND BC V7A 4X6

Page 1 of 1 02/21/06 18:37 CST
SO AP

SHIP TO: Phone: (604) 946-4152
INDUSTRIAL LASER CUTTING LTD
C/O CIKING PROFILES INC 604 821 0773
14471 KNOX WAY

BC V5V 2Z1

Order Number

90-373971

Purchase Order

110871

Total Packages: 1

Ship Via	Freight	Customer #	Sales	Tax Status	Contact	Certs	Due Date
STRAIT EXPRESS	FOB Warehouse Collect	443322	6 CD	TAXABLE		1	02/22/2006
Bill of Lading:	Pro Bill:	Ship Approval:		Ship Date:			Order Date:

Line No.	Item	Description	Qtv Shipped	B/O Quantity
1	5458-2572	AL SHT TL QQA250/8 5052H32 .032 X 48 X 96	3	3.00 UEA
Qty Comm:	3 SHTS	Order Qty: 3	UEA	
(1 -SKID 83 4X8)			ECS: 3	
Cntrl: 90277428 H: 467071		T: 467071	3 pcs Loc PEND	Wt: 43
PLS SHIP STRAIT EXPRESS COLLECT				
*** FILLED BY INITIALS: PD				

P.6: 450

Customer/Driver Instructions:
MILL TEST REPORTS REQUIRED ALL SHIPMENTS

Received by:

Date:

Acceptance of goods constitutes acceptance of our Terms and Conditions, available on our website at www.integrsmetals.com
(or from your sales representative, or by calling (800) 328-7800).

PACKING LIST

Alloys of Aluminum, Copper, Steel Caution:

Processing of this material may present a physical and/or health hazard. See material safety data sheets for further information

MATERIAL TEST REPORT

From: PECHINEY ROLLED PRODUCTS
CENTURY ROAD
P.O. BOX 68
RAVENSWOOD, WV , 26164

Page : 1
Heat/Lot : 467071
TIN : 467071

Gold To: INTEGRIS METALS, LTD.
12311 HORSESHOE WAY
RICHMOND , BC V7A 4X6

Ship To: 2306 "B" STREET NW
AUBURN WA
98002

Vendor Information

Cust. PO #: 20991

Cust. PO DT: 01/08/06

Specifications

RAVENSWOOD DISTRIBUTOR
SPEC COTI, NON HT MILL
AMS-QQ A 250/8
ALSO CONFORMS TO ASTM B209-04
Buyer Part: 54582309
5052 H32 .032 IN 48 IN

Mechanical Tests

	Min	UOM	L	O	Max	UOM	L	O
Number of Tests: 2								
Ult Tensile Str, Longitudinal	34.6	KSI	LONG		35.4	KSI	LONG	
Yield Strength	28.3	KSI	LONG		29.6	KSI	LONG	
Elongation, Longitudinal	9	PCT	LONG		9.5	PCT	LONG	

Chemical Composition

SI	Silicon-Pct	.130	FE	Iron-Pct	.040
CU	Copper-Pct	.040	MN	Manganese-Pct	.030
MG	Magnesium-Pct	2.340	CR	Chromium-Pct	.190
ZN	Zinc-Pct	.020	OF	Others Each Max-Pct	.050
OT	Others Tot Max-Pct	.150	Al	Remainder-Pct	

Comments

MATERIAL TEST REPORT

From: PECHINEY ROLLED PRODUCTS
CENTURY ROAD
P.O. BOX 68
RAVENSWOOD, WV , 26164

Page : 2
Heat/Lot : 467071
TIN : 467071

CERTIFICATION

Pechiney Rolled Products / Pechiney America

certifies that metal shipped under this order has been inspected and tested and found in conformance with the requirements of the applicable specifications as indicated herein. any warranty is limited to that shown on PRP(s) Standard General Terms and Conditions of Sales. Test reports are on file, subject to examination

PECHINEY ROLLED PRODUCTS

RAVENSWOOD OPERATIONS - RAVENSWOOD, WV. 26164

QA by MARK PARSONS 10/27/2005

Miscellaneous Data

Control #: 90277428 Date: 02/21/06

S.O. Number 590 373971 1

AL SHT TL QQA250X8 5052H32
.032 X 48 X 96

Customer P.O.: 110M/1

Feb 03/06

The Chemical Analysis and Mechanical Test data was received via EDI from the above mentioned vendor.

INTEGRIS METALS, LTD.